Work Order ID 63670

Tuesday, November 09, 2010 1:33:42 PM

ASAP

Item ID: D3912-1 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Eyebolt

Start Date: 11/9/2010 **Start Qty:** 6.00 **Cust Item ID:**

Required Date: 11/16/2010 **Req'd Qty:** 6.00 **Customer:**

Reference:

Approvals: **Process Plan:** CNC **Date:** 10-11-9 **Tooling:** **Date:** **Run Start** **Stop**

QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr / **Revision Nbr**									
D3912 / B									
100		0.00							
Doosan	**Memo**	0.00							
Doosan Lathe	TURN AS PER FOLIO FA871AND DWG Prog Rev: B Dwg Rev: B Deburr as required								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	**Memo**	0.00							
Quality Control									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: D3912-1 **PAR #:** _____ **Fault Category:** machining **NCR:** (Yes) No **DQA:** _____ **Date:** 10.11.17

Resolution: 1 & 2 scrap **Disposition:** 1 & 2 scrap **QA: N/C Closed:** _____ **Date:** 10/11/17

NCR: 63670		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			
(1) 10.11.11		• Cutting tool rapid into workpiece after untested changes were made via program network. R.C. Program.mod error.	DS 10/11/11	• Alert programmer + review process. • Scrap and replace. x1	10.11.11	JL 10/11/11	DS 10/11/11	10.11.11
(2) 10.11.11		• Part thickness under-size because when tool becomes dull after 2-3 pieces in 3/4" end mill will pull out of collet due	DS 10/11/11	• Replace dulled end mill • Try different collet • order 303 SS mat'l • Scrap + replace x2	10.11.11	JL 10/11/11	DS 10/11/11	10.11.11
		to the helical geometry of the cutting tool. even when mating surfaces are oil free. R.C. ~~material~~ Tooling.	DS 10/11/11					

• **NOTE:** Date & initial all entries

Work Order ID 63670

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Item ID: D3912-1 **Accept** **Setup Start** **Stop**

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Item Name: Eyebolt

Start Date: 11/9/2010 **Start Qty:** 6.00 **Cust Item ID:**

Required Date: 11/16/2010 **Req'd Qty:** 6.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00	JL 10/11/11			(6)			
QC	**Memo**	0.00							
Quality Control									
130	Identify as per dwg & Stock Location 095	0.00							
Packaging	**Memo**	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00							
Quality Control									

10/11/12 (6)

10/11/12 (6)

10-11-12 (6)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

- **NOTE:** Date & initial all entries

Picklist Print

Tuesday, November 09, 2010 1:33:41 PM

Work Order ID: 63670

Parent Item: D3912-1

Parent Item Name: Eyebolt

Start Date: 11/9/2010 **Required Date:** 11/16/2010

Start Qty: 6.00 **Required Qty:** 6.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R2.000 303 ROUND BAR 2"		Purchased	No			100	f	0.0000	0.25	1.578947	10-11-11		

5 of M112 939

M304R1.750

1.822

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	63070
Description: Eyebolt	Part Number:	D3912-1
Inspection Dwg: D3912 **Rev:** B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.13	+/-0.030	.13	✓		Vernier	all ok-02
Ø0.700	+/-0.010	.700	✓			
Ø0.500	+/-0.010	.500	✓			
0.90	+/-0.030	.900	✓			
0.13 x 45°	+/-0.030 x 0.5°	.13x45	✓			
0.22	+/-0.030	.218	✓			
0.75	+/-0.030	.75	✓			
0.970	+/-0.010	.968	✓			
1.72	+/-0.030	1.720	✓			
1.20	+/-0.030	1.200	✓			
0.625	+/-0.010	.626	✓			
2.23	+/-0.030	2.231	✓			
R0.13	+/-0.030	.140	✓			
R0.015	+/-0.010	.015	✓			
0.625	+/-0.010	.622	✓			
Ø0.650	+/-0.010	.650	✓			
1.100	+/-0.010	1.099	✓			
0.44	+/-0.030	.445	✓			
R0.13	+/-0.030	.125	✓			
1.00	+/-0.030	1.005	✓			
0.25	+/-0.030	.248	✓			
0.88	+/-0.030	.881	✓			
0.11	+/-0.030	.109	✓			
Ø0.719	+0.010/-0.000	.725	✓			

Measured by:		Audited by:		Preliminary Approval:	
Date:	10-11-11	Date:	10/11/11	Date:	

Rev	Date	Change	Revised by	Approved
A	10.06.07	New Issue	KJ	
B	10.08.09	Dimensions revised per Dwg Rev B	KJ	

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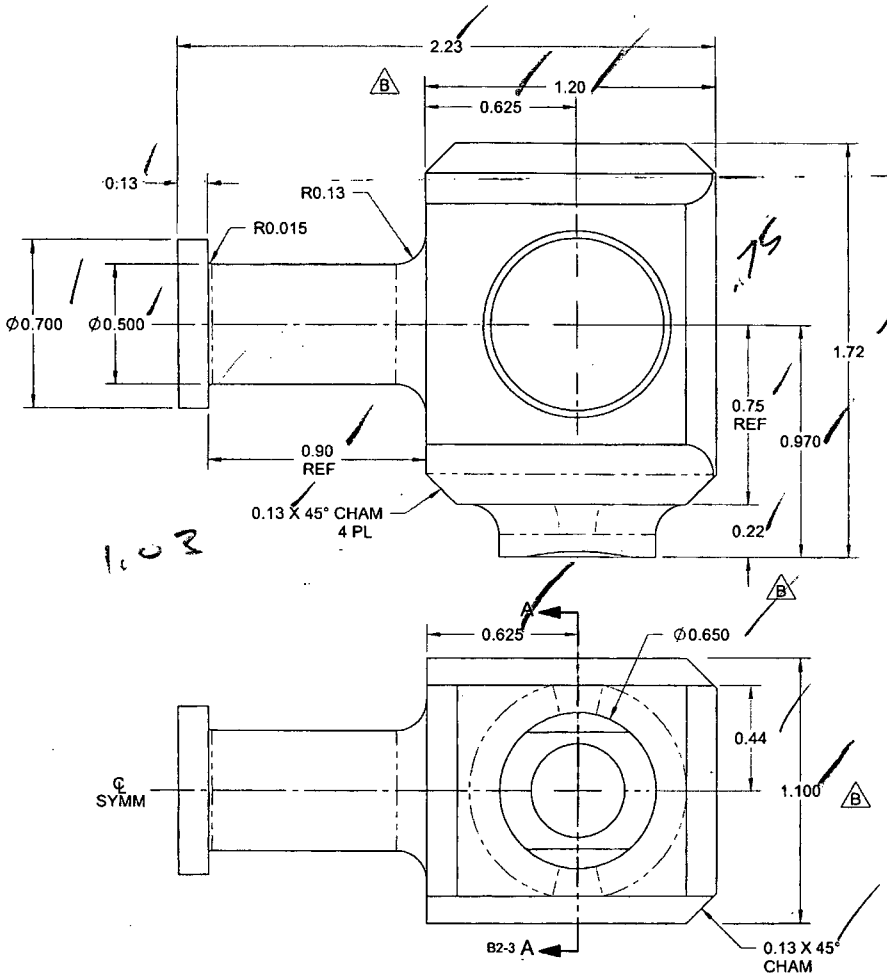
W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

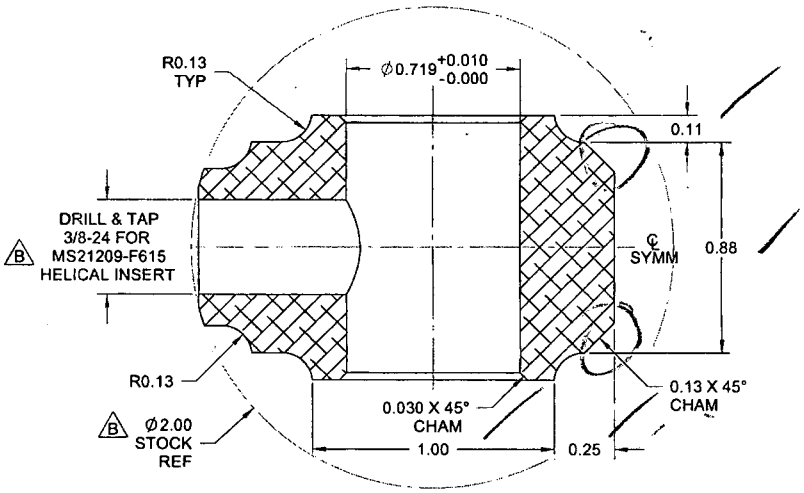
Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries





SECTION A-A B6-3

RELEASED
2010 -07- 16

D3912-1 EYEBOLT

NOTES:
1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582 REF DART SPEC M303R OR M304R
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ID AT ASSEMBLY
7) WEIGHT: 0.45 lbs

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		DRAWING NO. D3912 REV. B
CHECKED		SHEET 2 OF 3
MFG. APPR.		TITLE EYEBOLT RECEIVER ASSY
APPROVED		SCALE NTS
DE APPR.		
DATE	10.06.28	

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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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